

Date: Wednesday, 9/12/2007 12:14:12 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HANDLE WELDMENT
Job Number : 34622	
Estimate Number : 12089	
P.O. Number : <i>N/A</i>	Part Number : D3355041
This Issue : 9/12/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3355 REV B
Prsht Rev. : NC	Project Number : <i>N/A</i>
First Issue : <i>N/A</i> Type : LARGE FAB ASSY	Drawing Revision : B
Previous Run : 30789	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 9/21/2007 Qty: 4 Um: Each
Checked & Approved By : <i>[Signature]</i> 07.09.12	
Comment : est rev A 06.01.23 new issue EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	VA2160	SNAP BUTTON
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 ✓ SNAP BUTTON batch: *M16372*

*Pl 07.09.21* (4)

2.0	GP1R	Black Vinyl Grip
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 ✓ Black Vinyl Grip batch: *M16372 → 2*  
*M16871 → 2*

*Pl 07.09.21* (4)

3.0	D3355047	ADJUSTABLE EXTENSION
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 ✓ ADJUSTABLE EXTENSION batch: *B34636*

*Pl 07.09.21* (4)

4.0	D3355045	BOTTOM PART
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✓ Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 BOTTOM PART batch: *B34635*

*Pl 07.09.21* (4)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
 Assemble as per dwg D3355

*Pl 07.09.21* (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:   D   Date: 01/07/24  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/12/2007 12:14:12 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE WELDMENT

Job Number: 34622

Part Number: D3355041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5/09/21 (44)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57499

5/8/21 (4)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

5/09/24 (4)

Job Completion



5/09/24

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

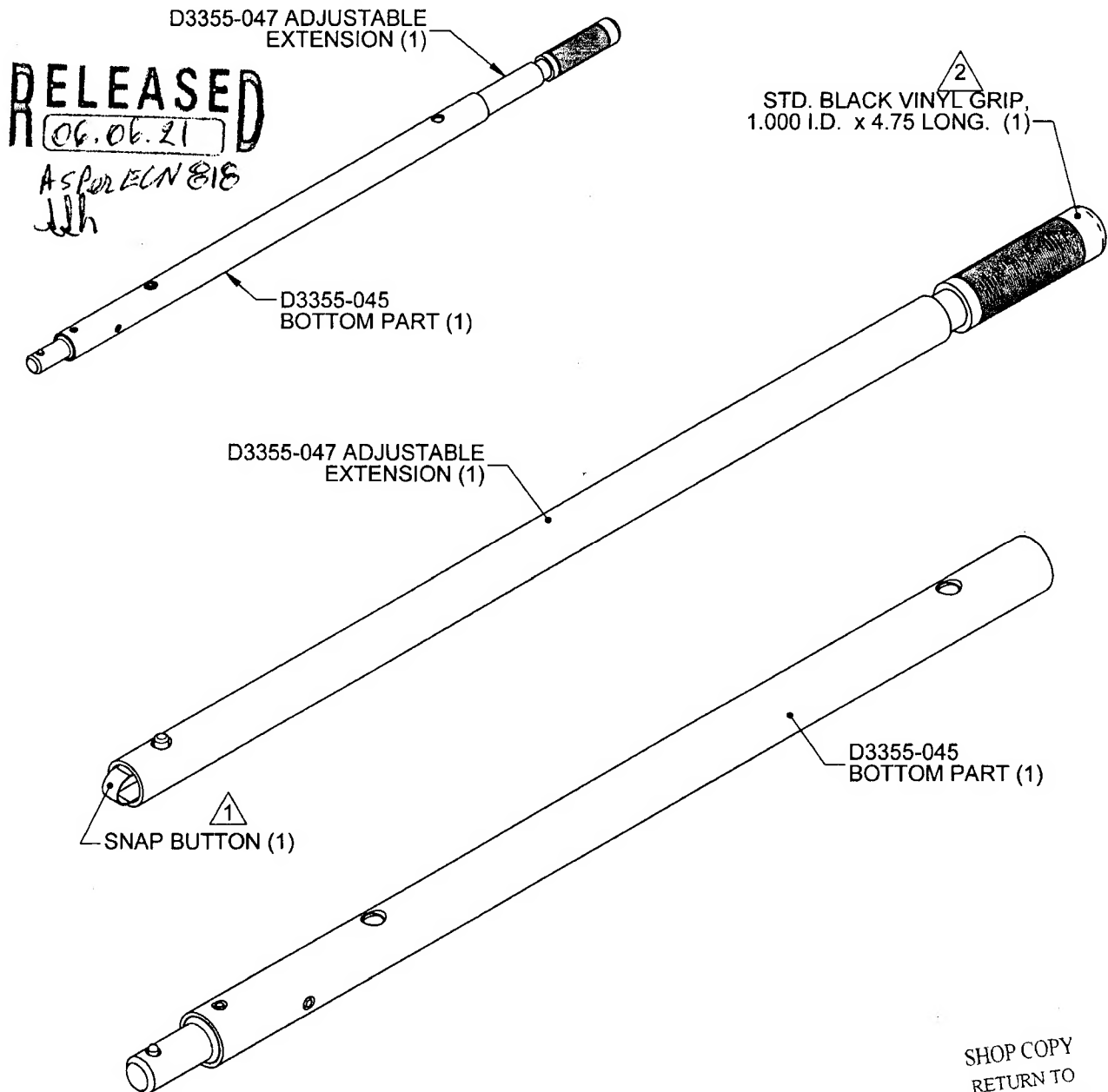
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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DATE <b>06.05.31</b>		TITLE <b>HANDLE WELDMENT</b>	SCALE 1:8
A	05.02.07	NEW ISSUE	
B	06.05.31	EDITED NOTE 1 (SHEET 2), UPDATE DETAIL B	



### D3355-041 HANDLE ASSEMBLY

#### NOTES:

- 1) POSSIBLE SUPPLIER: REID TOOLS SUPPLY CO. P/N VA-2160
- 2) POSSIBLE SUPPLIER: REID TOOLS SUPPLY CO. P/N GP-1R

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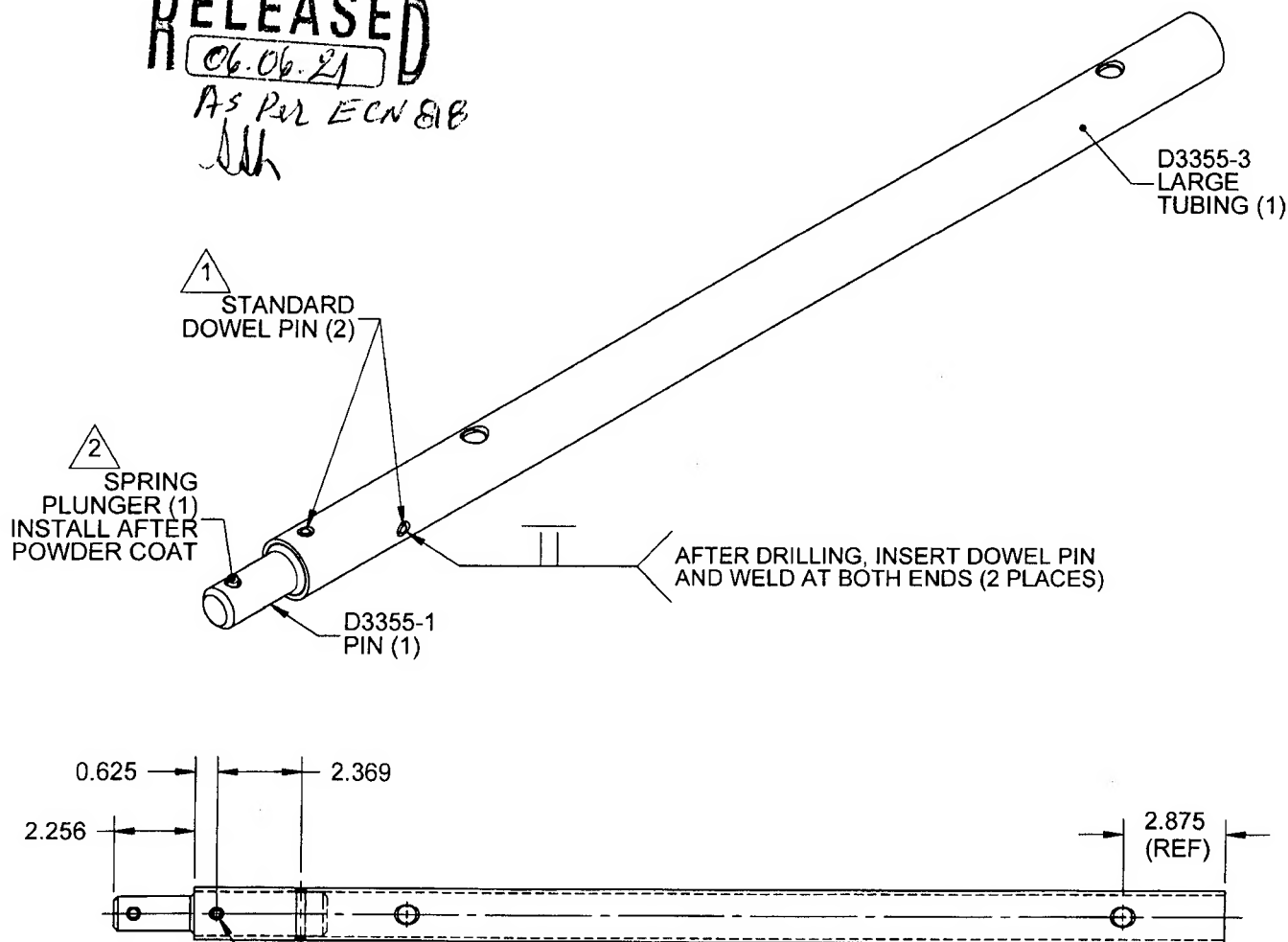


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DATE <b>06.05.31</b>	TITLE <b>HANDLE WELDMENT</b>		SCALE 1:5

**RELEASED**  
**06.06.21**

AS PER ECN 818

*[Signature]*



DRILL 90° FROM EACH HOLES  
Ø0.250 (DRILL THRU (2 PLACES) AND  
CHAMFER 0.06 x 45° (4 PLACES)

### **D3355-045 BOTTOM PART**

#### **NOTES:**

- 1) STEEL STANDARD GROUND DOWEL PIN, Ø0.250 X 1.50 LONG  
POSSIBLE SUPPLIER: SPAENAU, P/N 238-043
- 2) SPRING PLUNGER, POSSIBLE SUPPLIER: REID TOOLS SUPPLY CO. P/N VA-7130
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.5
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.010 TO 0.020

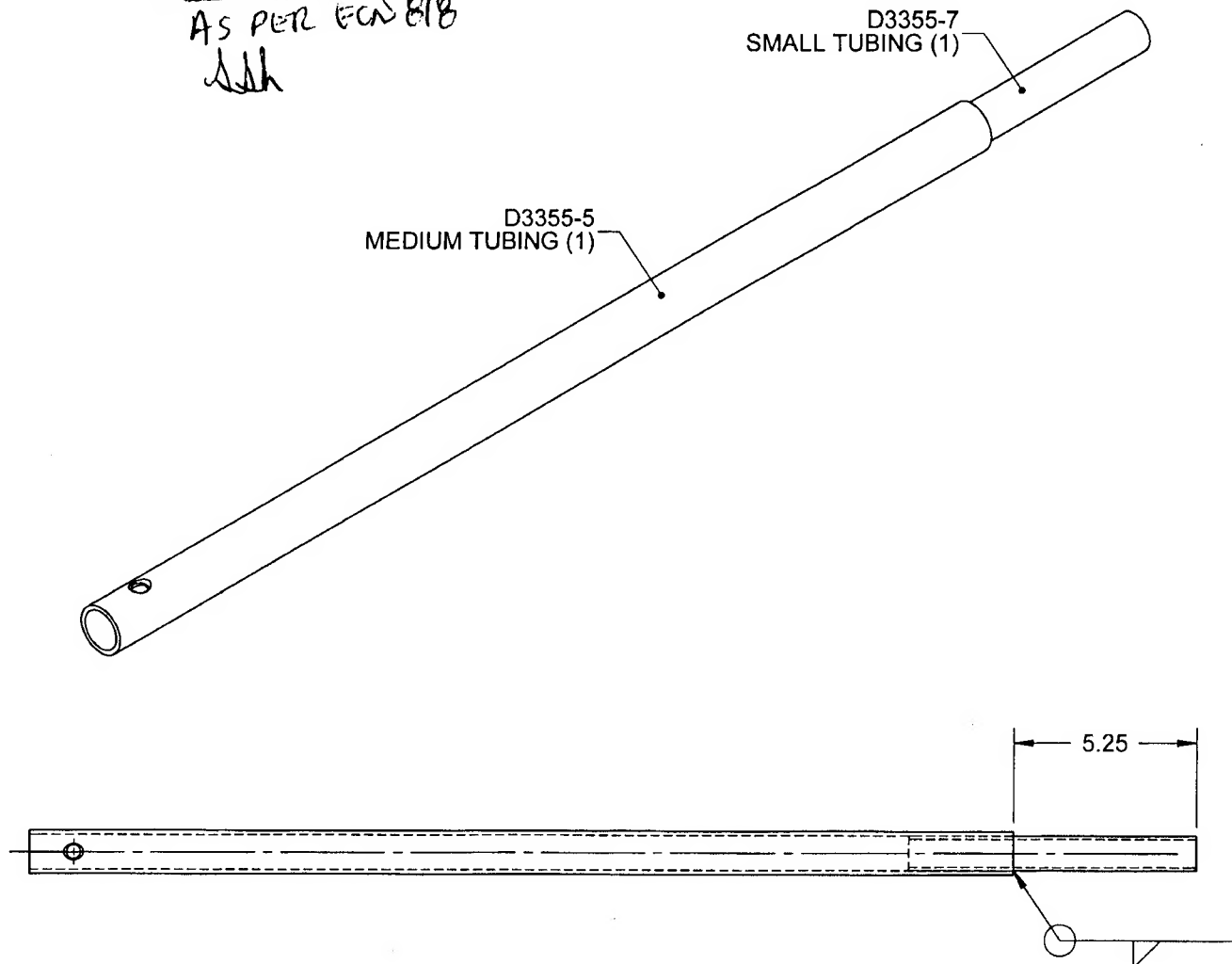
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DATE <b>06.05.31</b>	TITLE <b>HANDLE WELDMENT</b>		SCALE 1:5

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[Signature]**D3355-047 ADJUSTABLE EXTENSION****NOTES:**

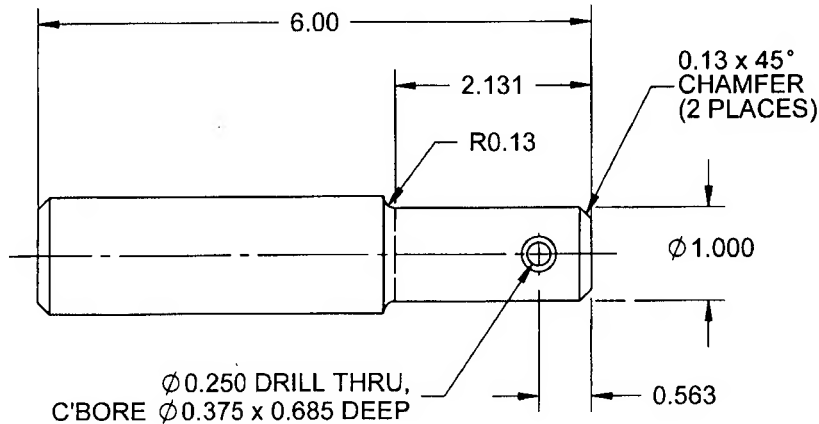
- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.5
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

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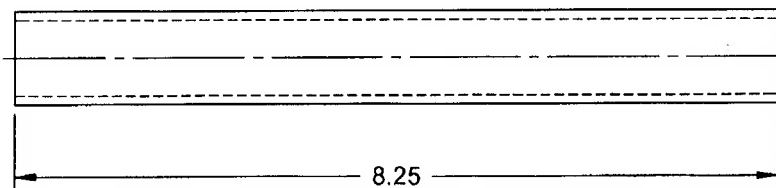
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DATE <b>06.05.31</b>		TITLE <b>HANDLE WELDMENT</b>	SCALE 1:2

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*06.06.21*  
*AS PER ECN 818***D3355-1 PIN****D3355-1 NOTES:**

- 1) MATERIAL: AISI-4130/ AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 ROUND BAR, (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

**D3355-7 SMALL TUBING****D3355-7 NOTES:**

- 1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING (REF. DART SPEC. M1020TR1.000W.095)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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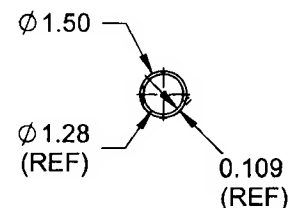
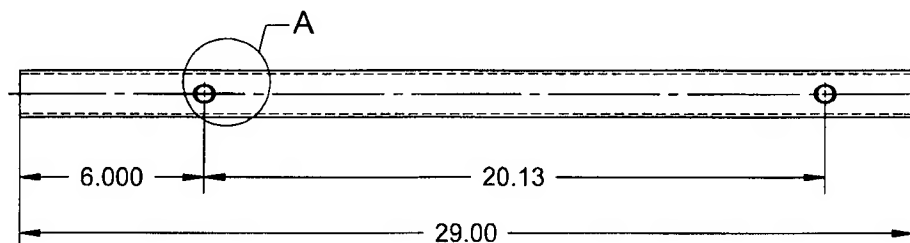
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DATE <b>06.05.31</b>	TITLE <b>HANDLE WELDMENT</b>	SCALE 1:6	

CHAMFER  $\phi 0.687$  (11/16)  
x 45°, 0.060 DEEP  
(2 PLACES)

$\phi 0.531$  (17/32) DRILL  
THRU (2 PLACES)

**DETAIL A**  
**SCALE 1 : 2**



### **D3355-3 LARGE TUBING**

#### **NOTES:**

- 1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING  
(REF. DART SPEC. M1020TR1.500W.109)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.015 TO 0.030

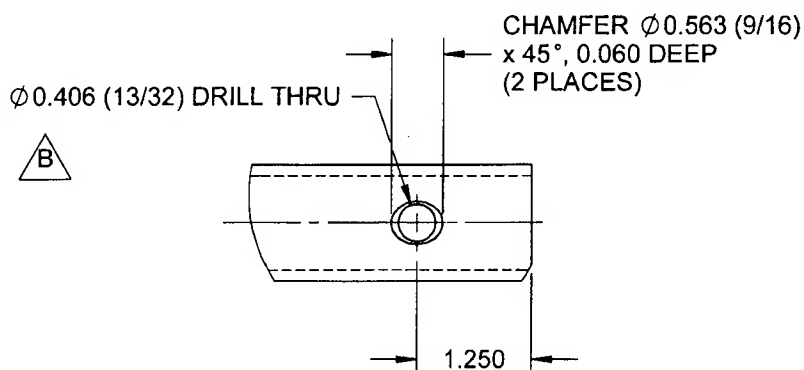
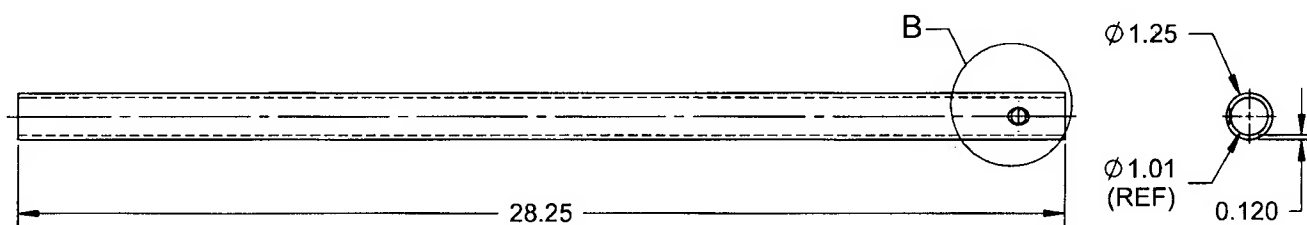
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DATE <b>06.05.31</b>		TITLE <b>HANDLE WELDMENT</b>	SCALE 1:5

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**SCALE 1 : 2****D3355-5 MEDIUM TUBING****NOTES:**

- 1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING  
(REF. DART SPEC. M1018TR1.250W.120)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.015 TO 0.030

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